

Date: Monday, 1/23/2006 7:51:33 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET, CLEVIS  
 Job Number : 25581  
 Estimate Number : 10109  
 P.O. Number : N/A Part Number : D2012115  
 This Issue : 1/23/2006 S.O. No. : N/A Drawing Number : D2012-115 REV. A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : A  
 Previous Run : 24559 Material : N/A  
 Due Date : 2/7/2006 Qty: 100 Um: Each  
 Written By : SEE COMMENT BELOW  
 Checked & Approved By : SEE ABOVE USER & DATE  
 Comment : Est: A 02.09.20 New issue KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 621

Laser cut as per Dwg D2012-115 (Note: 2 parts)

Material release note required

W 06-02-20 100

2.0 D2012115F Bracket, Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)  
 BRACKET, CLEVIS

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

C 206/03/09 119

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2012-115T1 &amp; T2

06-03-14

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr as required

M.H. M.F. 06/03/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET, CLEVIS

Job Number: 25581

Part Number: D2012115

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend per Dwg D2012-115 and bend Jig D2012-115T1

SB 06/03/21

1 part  
has 115  
1 part has 119

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-03-22

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Weld per Dwg D2012-115

Grind flush

06/04/07

Hermine M. 06-05-02 40

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Inspect weld and completeness on the W/O

06/05/10 (111)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST117

06/05/10 (111)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/15 (111)


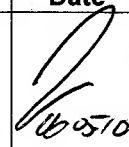
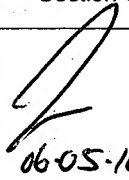
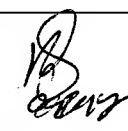
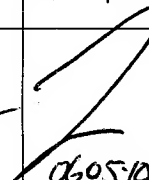
Job Completion



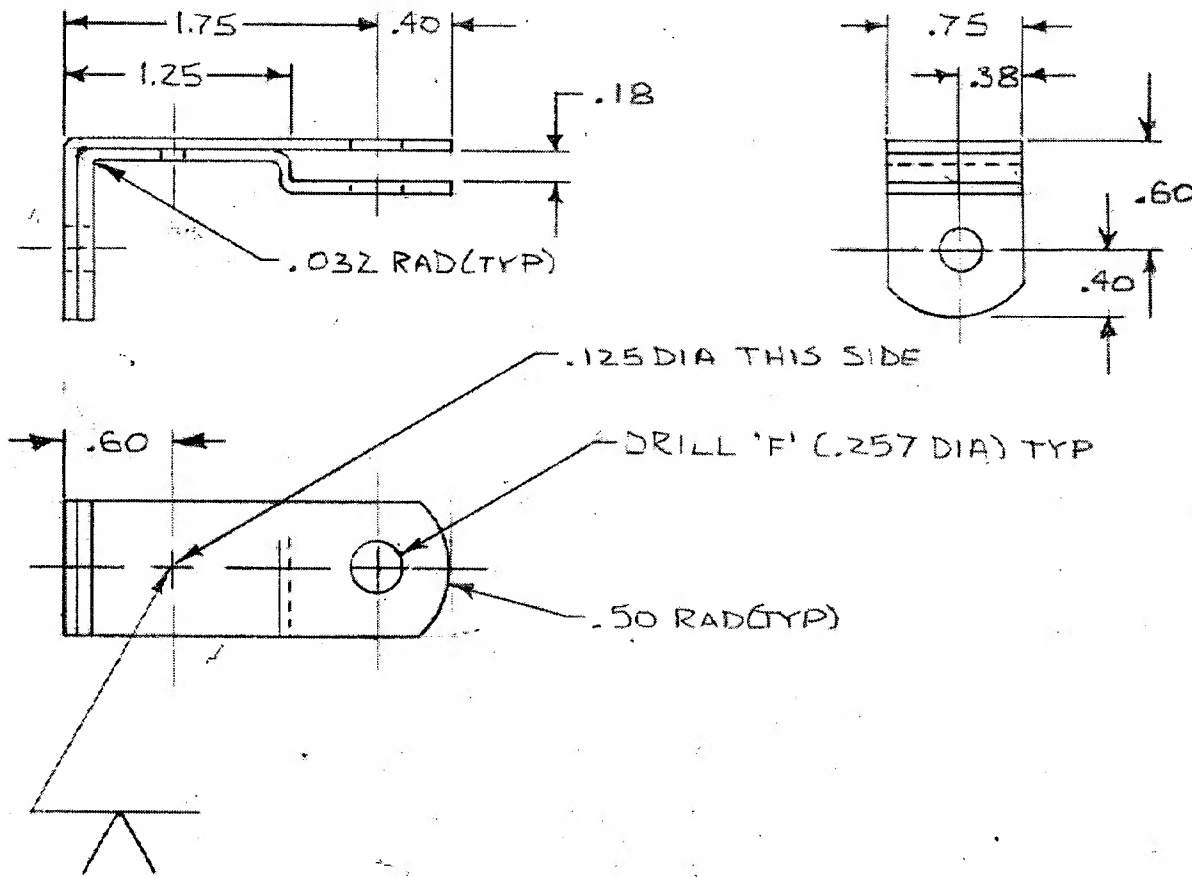
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 06/05/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-10	8	5 parts no good. Holes misaligned, <del>and</del> (2), and 3 were ground to much. Employee's first time.		Scrap: destroy	 06-05-10	 06-05-10		 06-05-10

NOTE: Date & initial all entries



RELEASED  
97/08/18 DS

NOTES: 1. MAT'L AISI 304/316 CRES  
.063 THICK

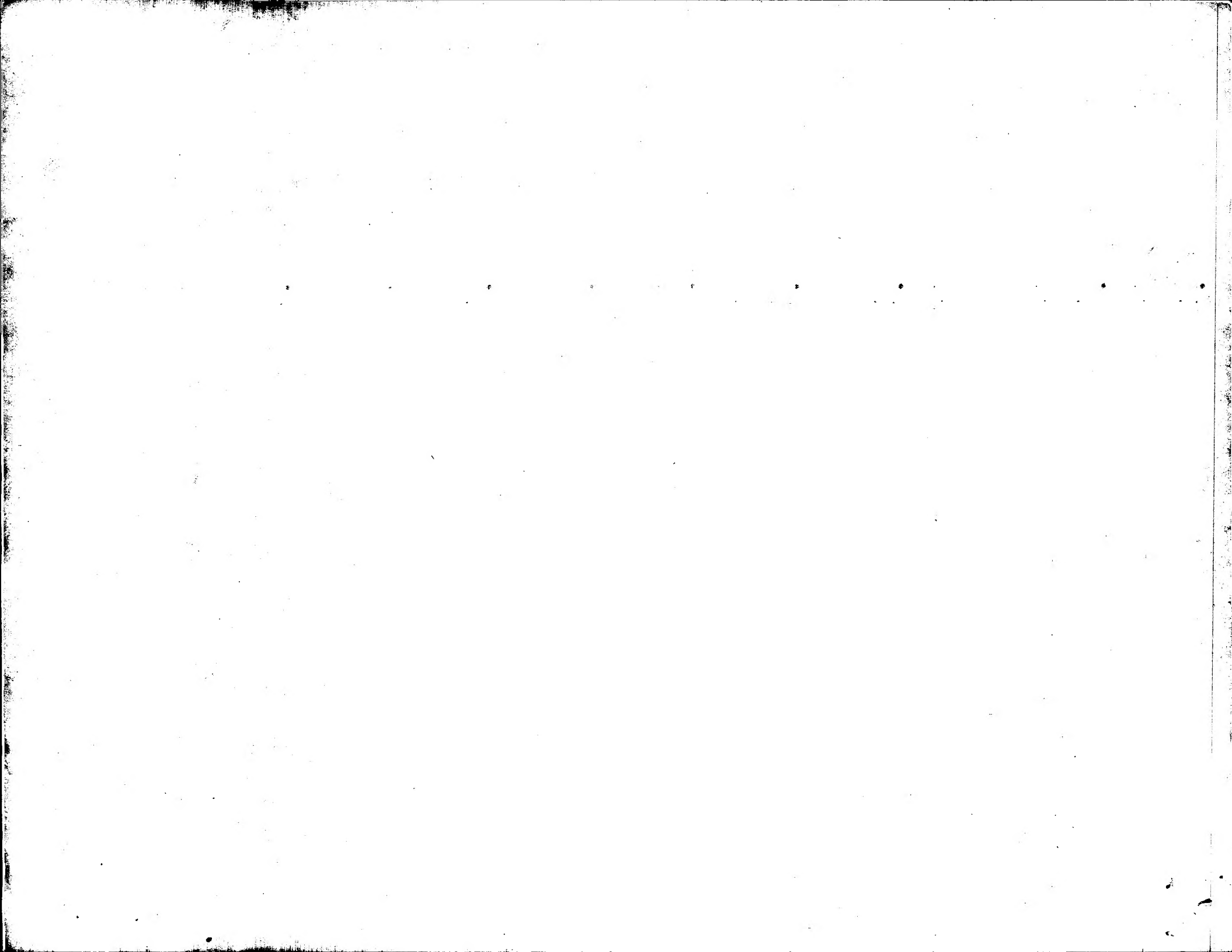
D2012-115

A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.  REQUIREMENTS - UNLESS OTHERWISE SPECIFIED GENERAL UNITS 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 8 - 7742 5. HOLES PER INCH 1000 1. TOLERANCES - .001 & .002 2. ANGLES 1/2" 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR	
	DRAWN		BASIC CODE	DIA. DASH NO. RY-HEAD NEAR SIDE	CONTRACT NO.	<b>DART</b> DART AERO ACCESSORIES INC. VANCOUVER CANADA				
	APPROVED		EXAMPLE DIMENSIONS OF SHEETS 6" SQUARE	LENGTH DASH NO. W/ SPOTWELD	DATE	DRAWN <b>HATTON</b> 04/03/92 DESIGN <b>BRADLEY</b> 7/13/91 STRESS CHECKED <b>BRADLEY</b> 11/4/8 CREW				
	DESCRIPTION OF CHANGE		BASIC CODES 6" x 12" x 1/4" 60-11320426AD		TITLE <b>BRACKET</b> CODE DWG NO. <b>D2012-115</b> REV <b>A</b> SCALE <b>FULL</b> SHEET <b>1</b> OF <b>1</b>					

REPORT ALL DISCREPANCIES - DO NOT SCALE

5/10/97 COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY

25581



# METALLURGICAL TEST REPORT

6870 Highway 42 East  
Ghent, KY 41045-9615  
(502) 347-6000

Certificate 185045 02  
Mail To:  
ALASKAN COPPER & BRASS CANADA, INC.  
P.O. BOX 3546  
SEATTLE, WA 98124-3546

Ship To:  
ALASKAN COPPER & BRASS CANADA, INC.  
225 NORTH ROAD AVENUE  
COQUITLAM, BC V3K3V7  
CANADA

Steel: 304

Finish: 2B

Corrosion: ASTM A262/01E; 180 Bend-OK

Your Order: V033868

NAS Order: AE 0249852 03

## PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.  
ASTMA240/01, A480/01, A666/00, ASME SA240/01, SA480/01, SA666/01  
QSS766D-A X MG PRM, AMS5513G X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

## REMARKS:

Material free from mercury contamination. No weld repairs.

Product ID #	Coil #	Thickness	Width	Weight	-----Length-----	Mark	Pieces
A96138	* 0415N6 D	.0600	60.0000	4,940	120.0000	SHEET 8	42

## CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
15N6	.059	18.401	.333	1.726	.366	.051	8.161	.029	< .001	.395

## MECHANICAL PROPERTIES

Product ID #	Coil #	l d o l c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail H Tail
A96138	0415N6	F T	96.06	49.79	43.68	85.00	88.00

P.O. 621